

# Work Order ID 86615

Thursday, July 05, 2012 3:38:02 PM

**\*86615\***

Page 1

Item ID: D2739

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: 350 I Beam

Stop **\*NS2\***

Start Date: 7/5/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

*MF*

Date: *2-07-05*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.  
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739  
3-Use uni-bit to open holes to finish size as per Dwg D2739.  
4-Bevel Fwd end of extrusion and Deburr holes and ends.  
5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

*4 SAD 12-07-08*

*W HGG 12-7-6*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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\*86615\*

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

Memo

0.00

Quality Control

H 8E12/07/06

140

Identify as per dwg & Stock Location: LG

0.00

\*140\*

Packaging

Memo

0.00

Packaging

④ SAD 12-07-06

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

CK 12/7/6  
YMK  
12-07-06

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Thursday, July 05, 2012 3:38:01 PM

Page 1

Work Order ID: 86615  
 Parent Item: D2739  
 Parent Item Name: 350 I Beam

Start Date: 7/5/2012  
 Start Qty: 4.00

Required Date: 7/19/2012  
 Required Qty: 4.00

Comments: IPP Rev: C02.11.28ReformatKJ  
 IPP Rev: D 06-03-21 As Per Rev C JLM  
 IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F 10.11.02 as per revE  
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108		Manufactured	No			100	Each	104.0000	1				
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Extrusion 'I Beam' thin

Location	Loc Qty	Loc Code
LG	104	
47814	20	
73909	84	

1 *SAD* 4 *12-07-28*  
*4*

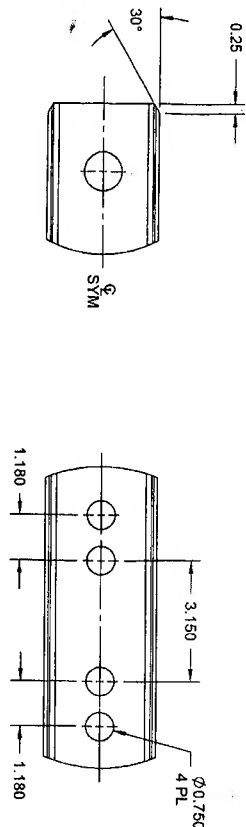
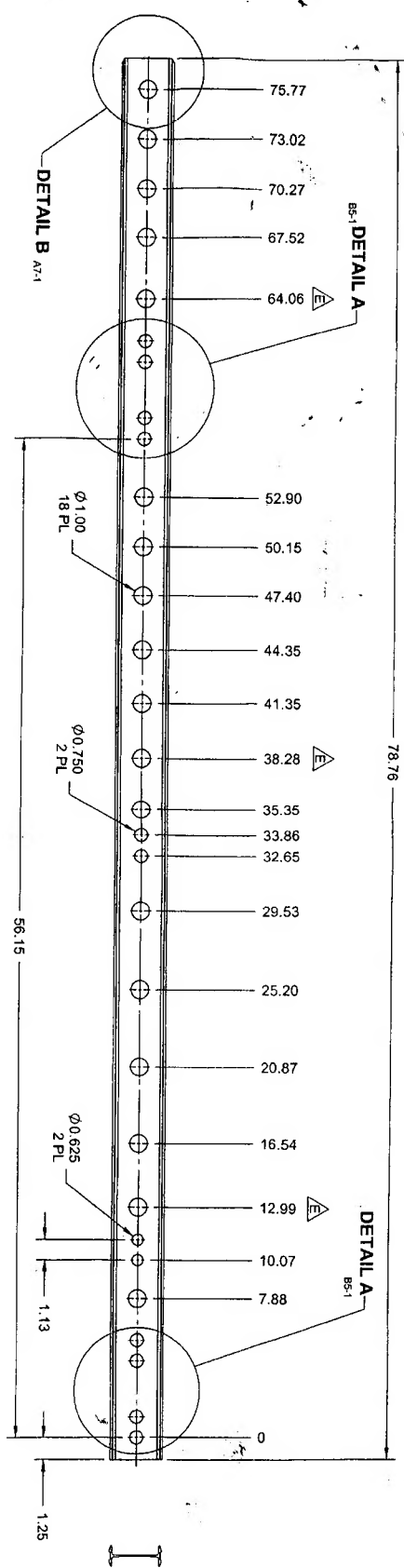
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**NOTE:** Date & initial all entries



DETAIL B  
SCALE 3X

DETAIL A  
SCALE 3X

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005.4.1
  - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART OSI 044.6.1
  - 7) WEIGHT: 3.41 lbs

REV.	DESCRIPTION	DATE
E	ADD/REMOVE HOLES FOR D4154 WEARPLATE. 38.28 WAS 38.25 (D2-1) & 64.06 WAS 64.17 (D7-1). ADD HOLE (D3-1)	10.10.08
D	ADD BEVEL TO FWD END. ADD DETAIL B	07.05.29
C	ADD/REMOVE HOLES FOR COMPATIBILITY WITH APICAL	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER	98.11.18
A	NEW ISSUE	98.04.16
DESIGN	DS	
DRAWN	CP	
CHECKED	CP	
MFG. APPR.	MP	
APPROVED	MP	
DE APPR.	MP	
DATE	10.10.08	

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2739

TITLE

WEB

SCALE

NTS

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RELEASED  
2010-11-01

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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